

Amendments to the Specification

Please replace the paragraph extending from line 9, page 2 to line 1, page 3, with the following amended paragraph:

Namely, before once ceasing the operation of a molding machine (melt-extrusion apparatus) for a long period of time (particularly for at least 4 hours) after carrying out a molding process, a process of purging the inside of a resin flow path in a molding machine with a purging agent is conventionally adopted, using high-density polyethylene (HDPE), low-density polyethylene (LDPE), linear low-density polyethylene (LLDPE), polystyrene (PS), polypropylene (PP) and the like as the purging agent (purging resin), and in order to shorten the time for purging, a process of employing a purging agent having higher viscosity than EVOH (purged resin), lowering ~~an~~the temperature for extrusion, or increasing the discharging amount is also utilized. However, these processes have problems such that a large amount of a purging agent is required and the operation is complex, also, using a purging agent having higher viscosity than a purged resin shortens a time for substituting a purged agent with a purging agent, however opposingly, at a time for substituting a purging agent with a purged agent when restarting the molding, a gel and a burn caused by the purging agent are continuously generated over a long time, which is a factor to expand loss of the product.

Please replace the paragraph in line 18, page 14 - line 6, page 15, with the following amended paragraph:

In the present invention, multi-layer melt-molding is carried out on EVOH at first by a conventionally ~~known~~known process adopting the above

described conditions. For example, by using a blow bottle molding machine equipped with a multi layer downward circular die having 30 to 200 mm $\phi$  on the tip of plural single-screw extruders equipped with a screw having L/D of 20 to 40, C.R. (screw's compression ratio) of 1.5 to 6.0, and 15 to 120 mm $\phi$ , EVOH is supplied into at least one extruder among the extruders, other resins (thermoplastic resins) besides the EVOH are supplied into other extruders, the temperatures in the extruders and the dies are set at 190 to 280°C, and molding a multilayer bottle can be carried out in a discharge amount of 0.5 to 500 kg/hr at the screw rotation number of 10 to 100 rpm. The EVOH residing in the molding machine is stood to be left without discharging (purging) throughout the period after forming a film (continuous melt-molding) for a certain time until restarting the melt-molding again.

Please replace the paragraph in lines 9-15 on page 16 with the following amended paragraph:

As for a process for maintaining the discharge amount, there is no particular limitation, however, a process in which changes in the melt-viscosity in an at each temperature of an each resin are comprehend detected and adjusting a leaving temperature corresponding to the changes lower than a processing temperature by 0 to 100°C or directly, a process of applying a plate for inhibiting flowing at the lip part in the die only during the period of being left and the like may be used.

Please replace the paragraph in line 11, page 17 - line 1, page 18, with the following amended paragraph:

Also, as the structure of the layers in the above described multilayer structure product, thermoplastic resin layers are to be the both outermost layers, referring to the EVOH (containing) layer as a and the thermoplastic resin layer as b, the layer structure can not only be b/a/b, but also b/a/b/a/b, and when a regrind layer comprising a mixture of the EVOH composition and the thermoplastic resin is referred to R, the layer structure can be b/R/a/b, b/R/a/R/b, b/a/R/a/b, b/R/a/R/a/R/b and the like, and the layer structure of a/b and b/R/a/b are preferably adopted, and in addition, it is possible to compound the mixture used in the regrind layer and an adhesive resin described later in b of these layer structures according the necessity. Further in these layer structures, an adhesive resin (such as a modified polyolefin resin with carboxylic acid) is used among each layer according to the necessity. Also, a thickness of the each layer depends on uses and a shape of a container, and required physical properties, however, the layer a is approximately 10 to 2000  $\mu\text{m}$  (further 30 to 500  $\mu\text{m}$ ), and the layer b is approximately 30 to 10000  $\mu\text{m}$  (further 100 to 5000  $\mu\text{m}$ ).

Please replace the paragraph in lines 20-27 on page 19 with the following amended paragraph:

In the blow molding at that time, an extruder for each layer was a single screw extruder having 30  $\text{mm}\phi$  equipped with a downward circular die having 21  $\text{mm}\phi$ , in which a resin capacity in the die was 140  $\text{cm}^3$ , was used. A ratio of an amount of a recovered resin to virgin HDPE was adjusted to be 1 % of

an EVOH amount in the recovering layer. Further, a set temperature in ~~an-all~~  
~~of the processing machine-machines~~ for each layer was ~~all-were~~ set at 210°C,  
and a temperature in a die was also set at 210°C.

Please replace the paragraph in lines 5-15 on page 21 with the  
following amended paragraph:

Example 3 was carried out in the same manner as Example 1, except  
for using EVOH having an ethylene content of 32 % by mol, a degree of  
saponification of 99.5 % by mol, MFR of 12 g/10 min (210°C, load of 2160 g),  
an amount of a boron compound of 380 ppm by boron conversion, an amount  
of magnesium acetate of 250 ppm by magnesium conversion, the melt-  
viscosity ratio of 4 and setting ~~an-of a~~ discharge amount of resin was 35 %,  
then the molding was restarted, it became possible to mold into a shape of a  
bottle after 4 minutes from initiating flowing a resin, and after further 21  
minutes, streaks disappeared and a bottle having excellent appearance was  
able to be obtained.